

Date: Thursday, 5/3/2007 11:30:20 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 32167	
Estimate Number : 10533	
P.O. Number : <i>N/A</i>	Part Number : D2573
This Issue : 5/3/2007	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : E
Previous Run : 32078	Material : <i>N/A</i>
	Due Date : 5/22/2007
Written By : _____	Qty: 12 Um: Each
Checked & Approved By : <i>ADD 2.05.03</i>	
Comment : Est. I As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2573
Ensure that grain is along 7.75" length
Batch No: _____

B 25353 (+12)

En 07/06/02

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. *B32167* Double check by: *SA*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

En 07/06/06

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

En 07/06/06

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 07/06/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:30:20 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 32167

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/06/06

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS 07-06-07

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR / SFL 07-06-08

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/6/8

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST433

PC 7/6/8 12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MS 07/06/11

(12)

Job Completion



MS 07-06-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2

DART AEROSPACE LTD		Work Order:	32167
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.748	1.749	1.747		
C	3.495	3.505		3.500	3.498	3.500	3.499		
D	1.745	1.755		1.749	1.748	1.749	1.747		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		0.502	0.493	0.498	0.498		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.503	0.502	0.503		
J	1.174	1.184		1.177	1.175	1.175	1.175		
K	0.558	0.578		0.567	0.565	0.567	0.568		
L	1.174	1.184		1.177	1.175	1.175	1.175		
M	1.365	1.375		1.365	1.366	1.366	1.366		
N	2.495	2.505		2.495	2.495	2.497	2.496		
O	4.119	4.129		4.121	4.119	4.121	4.122		
P	0.115	0.135		0.125	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.251	0.251	0.251		
S	0.115	0.135		0.120	0.120	0.123	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.237	0.236	0.236	0.238		
W	0.115	0.135		0.122	0.126	0.122	0.121		
X	0.308	0.313		0.310	0.310	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.627	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.249	0.244	0.246		
AE	1.500	1.520		1.512	1.514	1.513	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.246	0.249	0.248		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En
Date:	07/06/04

Audited by:	MS
Date:	07/06/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32167
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

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A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		8.001	8.001	7.999	8.003		
F	0.490	0.510		0.500	0.503	0.504	0.504		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.504	0.503	0.504	0.502		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.570	0.572	0.570		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.499	2.500	2.499		
O	4.119	4.129		4.121	4.122	4.122	4.121		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.250	0.251	0.251		
S	0.115	0.135		0.126	0.122	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.242	0.241	0.240		
W	0.115	0.135		0.130	0.128	0.131	0.128		
X	0.308	0.313		0.312	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.363	0.363	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.634	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.253	0.253	0.254		
AE	1.500	1.520		1.513	1.514	1.512	1.512		
AF	0.115	0.135		0.125	0.125	0.125	0.123		
AG	0.240	0.280		0.240	0.265	0.265	0.263		
AH	0.240	0.260		0.250	0.250	0.251	0.249		
AI	2.000	2.020		2.003	2.003	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	Er 19ml
Date:	07/06/05

Audited by:	MS
Date:	07/06/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.499	3.499	3.499		
D	1.745	1.755		1.750	1.750	1.750	1.749		
E	7.990	8.010		8.003	8.001	8.001	8.001		
F	0.490	0.510		0.504	0.504	0.503	0.504		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.503	0.503	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.570	0.570	0.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.499	2.499	2.499		
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R	0.240	0.260		0.251	0.251	0.252	0.251		
S	0.115	0.135		0.126	0.126	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.240	0.241	0.241		
W	0.115	0.135		0.130	0.128	0.129	0.129		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.363	0.363	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.624	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.247	0.247		
AE	1.500	1.520		1.513	1.512	1.512	1.512		
AF	0.115	0.135		0.125	0.122	0.123	0.123		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.248	0.249	0.250	0.249		
AI	2.000	2.020		2.002	2.002	2.001	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

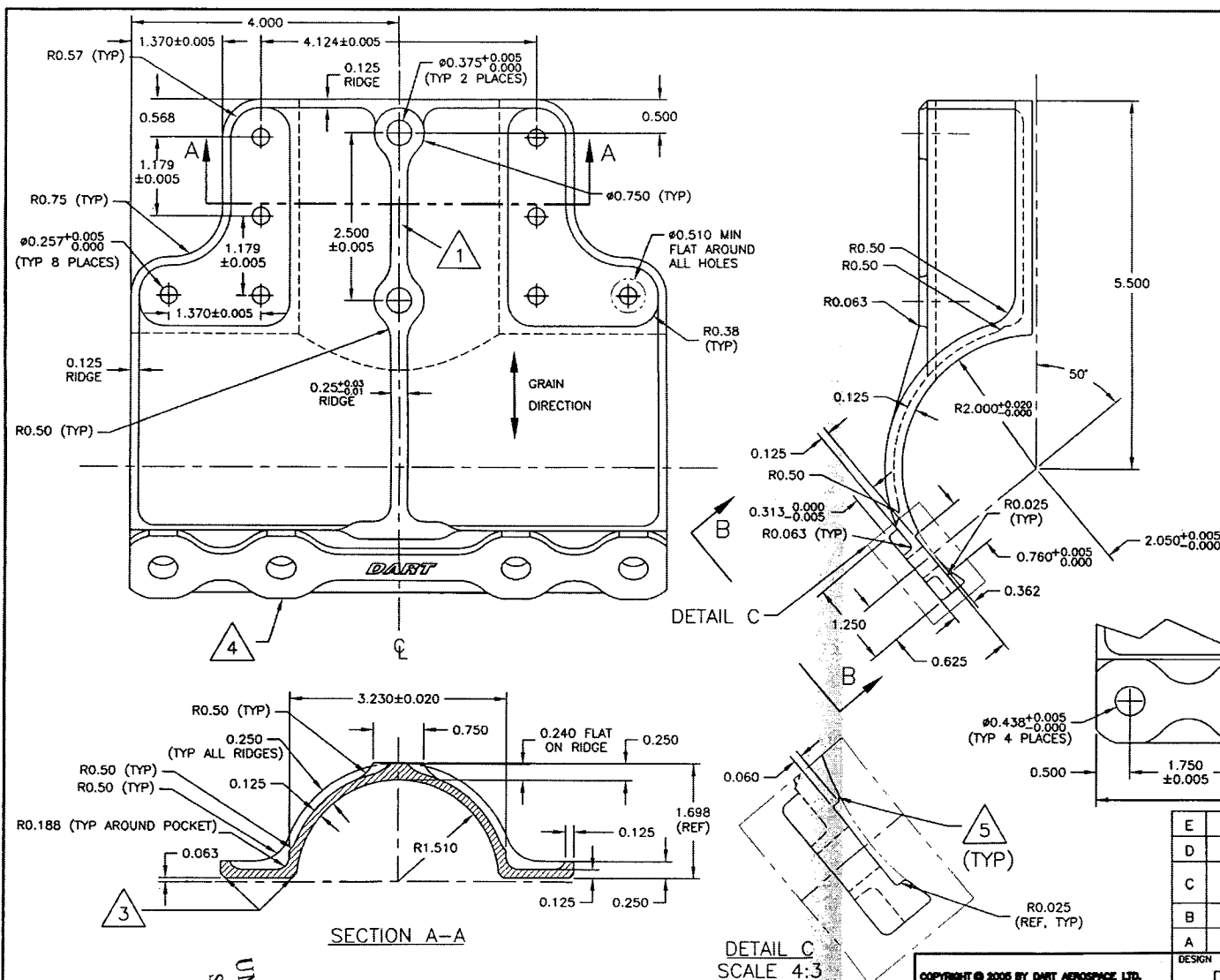
Measured by:	ML
Date:	07/06/06

Audited by:	MS
Date:	07/06/06

Rev	Date	Change	Revised by	Approved
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B	02.09.26	Re-format; Added Rev. D	KJ	
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RELEASED

05.12.06

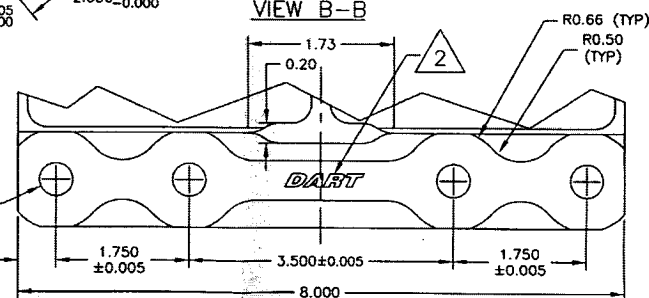


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
 (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2573
		TITLE OUTER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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